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**( Reaffirmed 1988 )**

*Indian Standard*  
**CODE FOR PACKAGING OF  
READY-MADE GARMENTS FOR EXPORT**  
*( First Revision )*

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**BUREAU OF INDIAN STANDARDS**  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

# *Indian Standard*

## CODE FOR PACKAGING OF READY-MADE GARMENTS FOR EXPORT

### ( *First Revision* )

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*Indian Standard*  
**CODE FOR PACKAGING OF  
READY-MADE GARMENTS FOR EXPORT**  
*( First Revision )*

**0. FOREWORD**

**0.1** This Indian Standard ( First Revision ) was adopted by the Indian Standards Institution on 30 June 1975, after the draft finalized by the Apparels Sectional Committee had been approved by the Textile Division Council.

**0.2** This standard was earlier published in two parts dealing with the packaging procedure of ready-made garments intended for export by sea and air separately. This revision, which combines both the parts has been taken up to incorporate the practices in vogue and at the same time ensuring the safe transit of the garments and preserving them from infestation and other deterioration.

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**1. SCOPE**

**1.1** This code prescribes the method of packing of ready-made garments intended for export by sea or air to ensure their safe transit. The requirements of the packing materials have also been specified.

**2. PACKING MATERIALS**

**2.1** The requirements of the packing materials specified in the standard are given in Table 1.

**3. PACKING PROCEDURE**

**3.1 Bale Packing**

**3.1.1 Make-up of Bundles** — Take a garment and fold it to the proper size. Place the required number of folded garments together to form a bundle. Wrap each bundle with polyethylene film of minimum 25 micron thickness. Alternatively, a bag made of such a film may be used for enclosing the bundle. Tie it securely with suitable cotton or jute twine.

TABLE 1 REQUIREMENTS OF PACKING MATERIALS

( Clause 2.1 )

SL No.	MATERIAL	REQUIREMENT
(1)	(2)	(3)
i)	Polyethylene film	25 to 40 microns thick ( <i>see</i> IS : 2508-1963* )
ii)	Polyethylene bags	Made from 25 to 40 microns thick polyethylene film ( <i>see</i> IS : 2508-1963* )
iii)	Kraft paper	<i>See</i> grade 2 of IS : 1397-1967†
iv)	Waterproof paper	Manufactured from 2 plies of kraft paper laminated with bitumen ( <i>see</i> Type I of IS : 1398-1968‡ )
v)	Cardboard boxes	Made from folding box board ( <i>see</i> IS : 1776-1961§ )
vi)	Cartons	Made from corrugated fibre-board of minimum 7 plies for carton packing and 5 plies for post parcel packing ( <i>see</i> IS : 2771-1965   )
vii)	Hessian	229 and 305 g/m <sup>2</sup> { <i>see</i> IS : 2818 ( Part II )-1971¶ }
viii)	Wooden case	<i>See</i> Fig. 1
ix)	Steel strips:	
	a) Bale packing	Medium grade having a width 20 mm, <i>Min</i> and thickness 0.9 mm, <i>Min</i> ( <i>see</i> IS : 1029-1970** )
	b) Case packing	Hard grade having a width 12.5 mm, <i>Min</i> and thickness 0.5 mm, <i>Min</i> ( <i>see</i> IS : 1029-1970** )

\*Specification for low density polyethylene films.

†Specification for kraft paper ( *first revision* ).‡Specification for packing paper, waterproof, bitumen-laminated ( *first revision* ).

§Specification for folding box board, uncoated.

||Specification for corrugated fibre board boxes.

¶Specification for Indian hessian: Part II 305 and 229 g/m<sup>2</sup> at 16 percent contract regain ( *first revision* ).\*\*Specification for hot rolled steel strips ( *baling* ) ( *first revision* ).

**3.1.2 Make-up of Bales** — The bales shall satisfy the following requirements:

- a) The sequence of layers is hessian, 229 g/m<sup>2</sup>; polyethylene film and; hessian, 305 g/m<sup>2</sup>, in such a way that when the bale is finally made up, the hessian, 305 g/m<sup>2</sup>, forms the outermost layer. The packing materials are in sound and dry condition and are of such sizes that the overlaps are at least 10 cm.

**NOTE** — Hessian 305 g/m<sup>2</sup> laminated with polyethylene film may be used in place of the two layers separately.

- b) The lips of end pieces of hessian are stitched with 2 strands of jute twine of adequate strength with at least 5 stitches/dm on all the four sides.



- c) The bale is bound by cross hooping the steel strips over cardboard pieces at right angles to both the length and width of the bale. The strips nearest to the edges are appearing 15 cm from the respective edges and other strips equally positioned at approximately 20 cm from each other. The strips are covered with hessian in order to avoid the cutting of the bale.

**NOTE** — Wooden or bamboo slats of adequate length and strength may be used under the strips at each of the 8 edges of the bale in place of cardboard pieces.

### 3.2 Case Packing

**3.2.1 Make-Up of Boxes or Packets** — Take a garment and fold it to the proper size using suitable stiffeners such as cardboard, tissue paper or butter paper, which do not stain the garments (*see* Note 1). Secure the folds of the garment by means of brass or aluminium pins (*see* Note 2) or plastic clips. Pack each of the folded garments in a polyethylene bag. Take the required number of such garments and put them in a cardboard box or wrap them with kraft paper to make them into a packet (*see* Note 3). If agreed upon, the garments may be packed in wooden cases in loose form that is without putting them in cardboard box or making them into packets.

**NOTE 1** — Garments like workers' overalls, flannel pyjamas and mazri shirts may be folded without the use of stiffeners.

**NOTE 2** — The brass or aluminium pins should not stain the garments.

**NOTE 3** — Garments like shirts and trousers are generally packed individually, pyjama suits in sets, and smaller items like neck-ties in a suitable number.

**3.2.2 Make-Up of Cases** — The cases (*see* Note 1) shall satisfy the following requirements:

- a) The sequence of layers of polyethylene film and waterproof paper (*see* Note 2) is such that when the contents are packed, the waterproof paper forms the outer layer. The wrapping materials are in sound, clean and dry condition and are of such size that the overlaps are at least 10 cm.
- b) The outer layer is either sealed with adhesive tape or tucked securely to the sides of the case and the lid firmly nailed to the case.
- c) The case is bound with steel strips in such a way that at least 2 strips are positioned parallel to the battens and 1 strip is positioned at right angle to the battens, the strips being in tight condition.

**NOTE 1** — The cases shall be treated for rendering them antitermite, etc.

**NOTE 2** — Hessian, 305 g/m<sup>2</sup>, laminated with polyethylene film may be used in place of polyethylene film and waterproof paper.

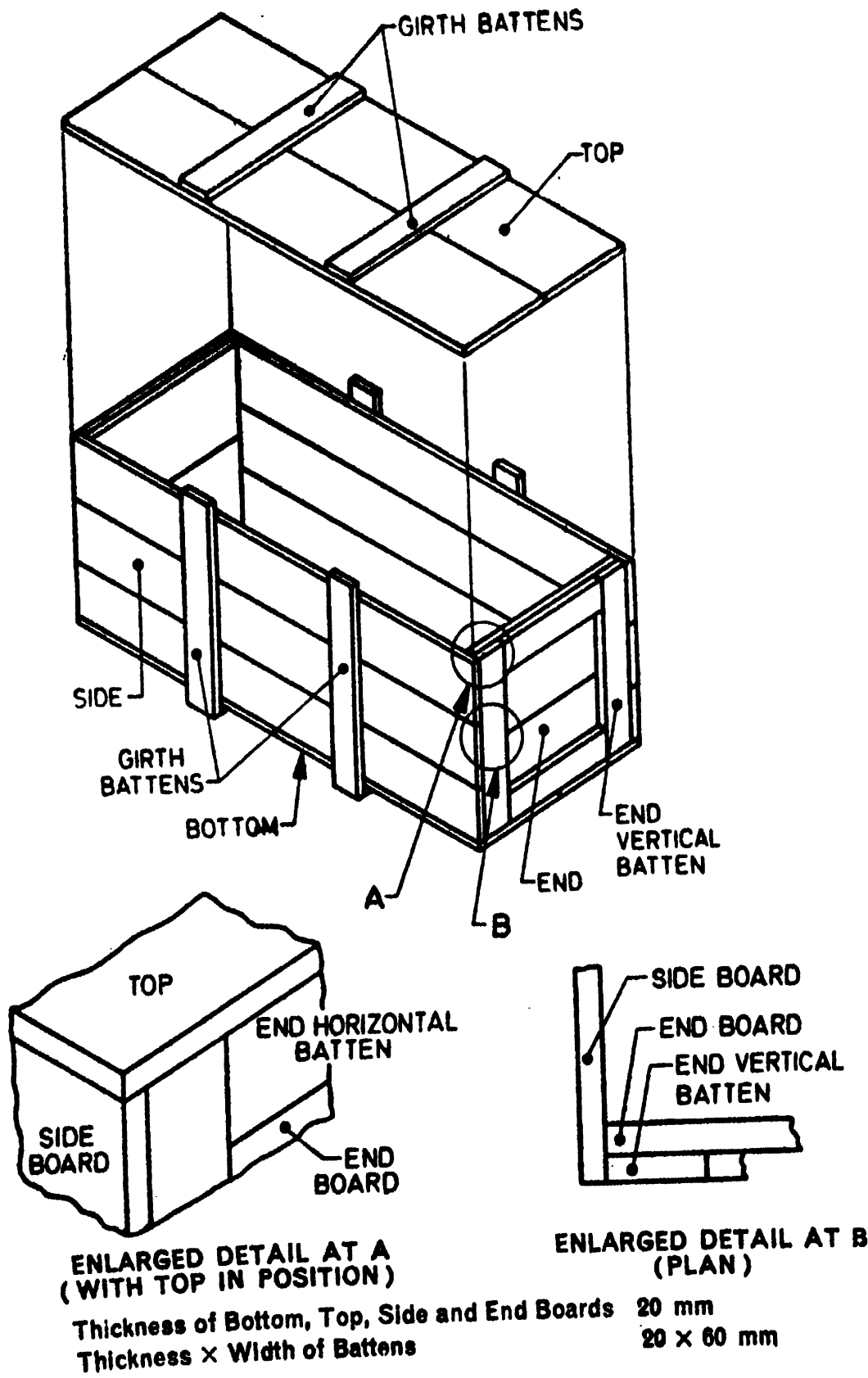


FIG. 1 PACKING CASE

### 3.3 Carton Packing

**3.3.1 Make-Up of Boxes or Packets** — The boxes and packets shall be made up as given in 3.2.1.

**3.3.2 Make-Up of Cartons** — The cartons shall satisfy the following requirements:

- a) The carton is lined with a layer of waterproof paper or polyethylene film of sufficient size to cover fully the contents. This layer is either sealed with a suitable adhesive or tucked securely to the sides of the carton.
- b) The lid of the carton is sealed with a suitable adhesive tape.
- c) The carton is bound securely either with steel strips or high density nylon, plastic or polyethylene straps suitably positioned around the cartons.

### 3.4 Post-Parcel Packing

**3.4.1 Make-Up of Boxes or Packets** — The boxes and packets shall be made up as given in 3.2.1.

**3.4.2 Make-Up of Cartons** — The cartons shall satisfy the following requirements:

- a) The carton is lined with a layer of waterproof paper or polyethylene film of sufficient size to cover fully the contents. This layer is either sealed with a suitable adhesive or tucked securely to the sides of the carton.
- b) The lid of the carton is sealed with suitable adhesive.
- c) The carton is bound either with 2 round steel wires of 2 mm diameter positioned at right angles to the length of the carton, each wire being 15 cm away from the respective edge of the carton and one similar wire positioned at right angles to the width of the carton in the centre, or with high density nylon, plastic or polyethylene straps.
- d) Wrap the carton with a cotton cloth or hessian, 229 g/m<sup>2</sup>. Stitch the cloth around the carton with a sewing thread of adequate strength using about 6 to 10 stitches/dm (6 for hessian and 10 for cotton cloth covering) taking care not to pierce the inner wrapping during stitching.
- e) Seal the seam of the cloth with sealing wax all around the carton positioning the seals at equal distance of approximately 10 cm from each other.

**Note** — The size and weight of the package shall not exceed the limits prescribed by the concerned authorities.

**4. MARKING**

**4.1** Each bale, wooden case or carton shall be marked with the following:

- a) Leading mark ( consignee's name or initials );
- b) Destination;
- c) Serial number of the consignment;
- d) Gross and net weight of the package;
- e) Manufacturer's name, initials or trade-mark and country of origin;  
and
- f) Any other information required by the buyer or by the law in  
force.

**4.2** The cartons for air-shipment shall be marked with the following:

- a) Leading mark ( consignee's name or initials );
- b) Destination;
- c) Serial number of consignment;
- d) Country of origin; and
- e) Any other information required by the buyer or by the law in  
force.

**4.3** All markings shall be legible and indelible.



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